

Work Order ID 59605

Tuesday, June 08, 2010 3:04:46 PM



Page 1

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Assembly (350)

Stop



Start Date: 6/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-6-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4032	C

100 Pick Kit 0.00



Packaging

Memo

0.00

EBro/6/15 O

Packaging 0.00

110 Assemble as per dwg 0.00



HandFinish

Memo

0.00

EBro/6/15 O

Hand Finishing 0.00

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

S.06/06/15
(H)

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 1
8

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2530



Handle Weldment

Manufactured No

100

Each

1.0000

1

1



59184

C

D2535



Spring

Manufactured No

100

Each

126.0000

2



2

C

D2537



Bushing

Manufactured No

100

Each

33.0000

4



16308

C

D3917-3



Washer

Manufactured No

100

Each

49.0000

6



56429

6

C 10/15 ①

Location

Loc Qty

Loc Code

ST504

33

58429

33

Location

Loc Qty

Loc Code

ST096

49

57144

1

58892

48

58892

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 2

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC IPP Rev:B as
10.03.23 verified by:EC IPP Rev:C as per RevA DD
verified by:EC IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

D3953-3



Manufactured No

100

Each

13.0000

2

2

Gas Spring Stud, Lid

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST102	13	
	13	

D3953-7



Manufactured No

100

Each

13.0000

2

SP 884

Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST103	13	
	13	

D3953-9



Manufactured No

100

Each

9.0000

2

SP 883

Gas Spring Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST101	9	
	9	

D3953-17



Manufactured No

100

Each

9.0000

2

SP 692

Gas Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST101	9	
57143	1	
58857	8	

SP 887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 3

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC IPP Rev:B as
10.03.23 verified by:EC IPP Rev:C as per RevA DD
verified by:EC IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

D3953-19



Manufactured

No

100

Each

18.0000

1

1

Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST101	4	
57607	4	
ST103	14	

57607

D3953-21



Manufactured

No

100

Each

29.0000

1

1

Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ENG	5	
56407	5	
ST102	24	
57145	7	
59214	17	

57145

D3969-3



Spring (Basket Lid)

Manufactured

No

100

Each

14.0000

1

1

10-6-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST	14	
56386	2	
58986	12	

56 386

D4017-041



Short Basket Base Assembly (350)

Manufactured

No

100

Each

0.0000

1

1

B59606(①)

EBO/06/15①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

Tuesday, June 08, 2010 3:04:45 PM

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D4018-041 	Manufactured	No	100	Each	0.0000	1	1	<i>6/9/10/15</i>
Short Basket Lid Assembly (350) 	Purchased	No	100	Each	42.0000	4	4	
AN3-14A 	Purchased	No	100	Each	149.0000	2	2	<i>114330</i>
Bolt 	Purchased	No	100	Each	149.0000	2	2	
AN3-16A 	Purchased	No	100	Each	149.0000	2	2	<i>113890</i>
Bolt 	Purchased	No	100	Each	70.0000	3	3	
AN4-12 	Purchased	No	100	Each	70.0000	3	3	<i>114292</i>

Tuesday, June 08, 2010 3:04:45 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 5

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC IPP Rev:B as
10.03.23 verified by:EC IPP Rev:C as per RevA DD
verified by:EC IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

AN5-17A



Purchased

No

100

Each

161.0000

4

4



Bolt

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST323	114324	15	114329
	114330	15	
ST339	114330	146	
	114784	100	
		46	

AN310-4



Purchased

No

100

Each

29.0000

3

3



NUT

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	114716	26	114718
	114341	26	
ST349		3	
		3	

AN310C4



Purchased

No

100

Each

60.0000

2

2



Nut

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	114306	60	114306

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 6

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC IPP Rev:B as
10.03.23 verified by:EC IPP Rev:C as per RevA DD
verified by:EC IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

MS21042L3



Purchased

No

100

Each

3,364.000

6

6

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3364	
113537	18	
113644	5	
114523	841	114523
114718	500	
114784	2000	

MS21042L5



Purchased

No

100

Each

768.0000

4

4

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	500	
114813	500	
ST300	268	
114449	268	

MS24665-151



Purchased

No

100

Each

656.0000

3

3

Cotter Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	656	
17566	656	17566

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 7

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC
per PA3 DD 10.03.10 verified by:EC IPP Rev:B as
10.03.23 verified by:EC IPP Rev:C as per RevA DD
verified by:EC IPP Rev:D as per dwg revC DD 10.04.20

Start Qty: 1.00

Required Qty: 1.00

MS24665-300



Purchased

No

100

Each

70.0000

2

2

in C

Cotter Pin

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	70	
105279	2	
110123	68	

NAS1149F04463P



Purchased

No

100

Each

165.0000

6

110123

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	165	
114223	65	
114348	100	

NAS1149C0432R



Purchased

No

100

Each

752.0000

2

m114223

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	752	
114292	152	
114742	600	

NAS1149F0363P



Purchased

No

100

Each

181.0000

8

114292

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	181	
113254	81	
114382	100	

113264

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 3:04:45 PM

Page 8

Work Order ID: 59605



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 6/9/2010

Required Date: 6/14/2010

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

234.0000

4

4



Washer

JL 10-6-15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	34	
108471	34	<u>108471</u>
ST298	200	
114576	200	

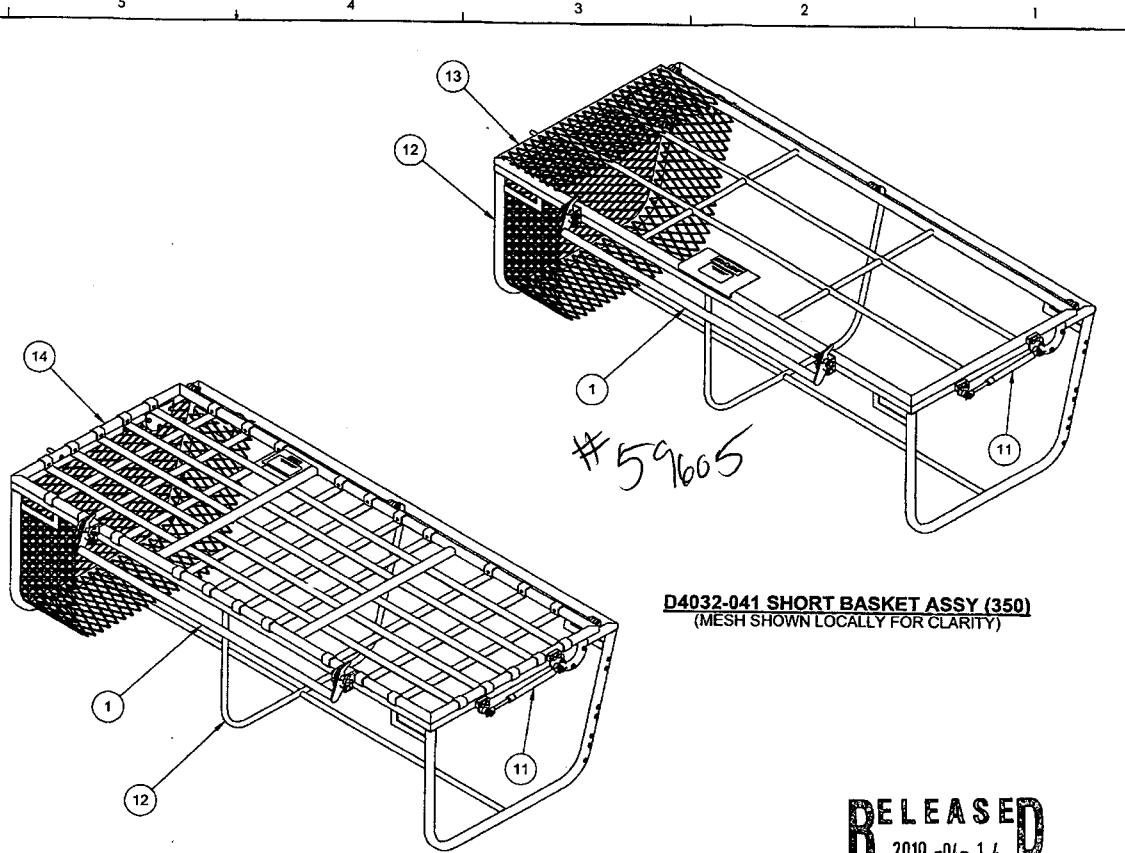
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2		NAS1149C0432R	WASHER
29	8		NAS1149F0332P	WASHER
30	4		NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-14
MP

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

C	AN5-21A BOLT WAS AN5-19A BOLT; BOM & (D3-3)			JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD; PLACARDS REMOVED (C6-2);			JPH	10.03.25
A	TOP VIEW DETAIL REMOVED (C2-2)			JPH	10.03.08
REV.	NEW ISSUE			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		D4032	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.		SHORT BASKET ASSY (350)	NTS		
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

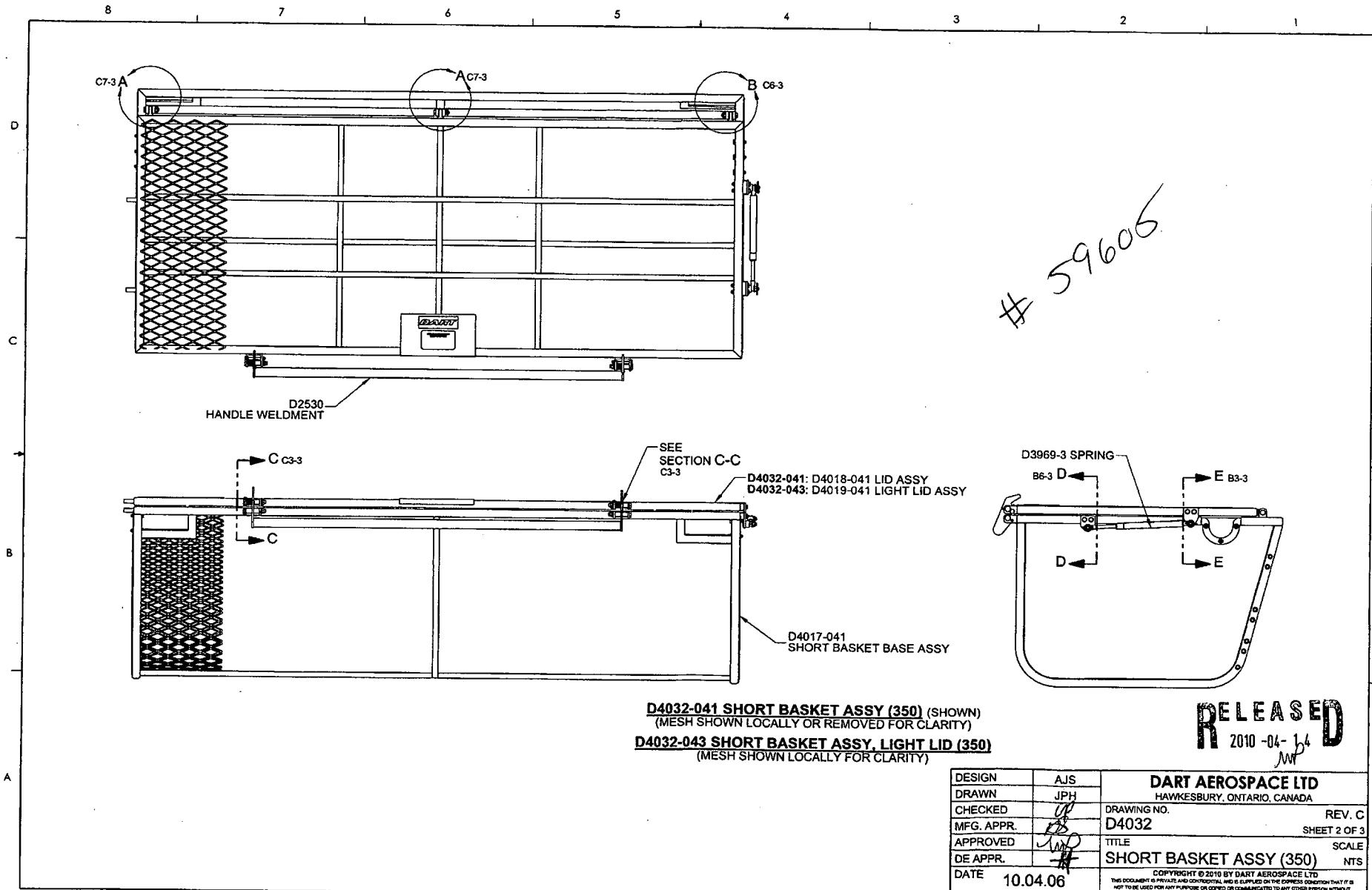
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

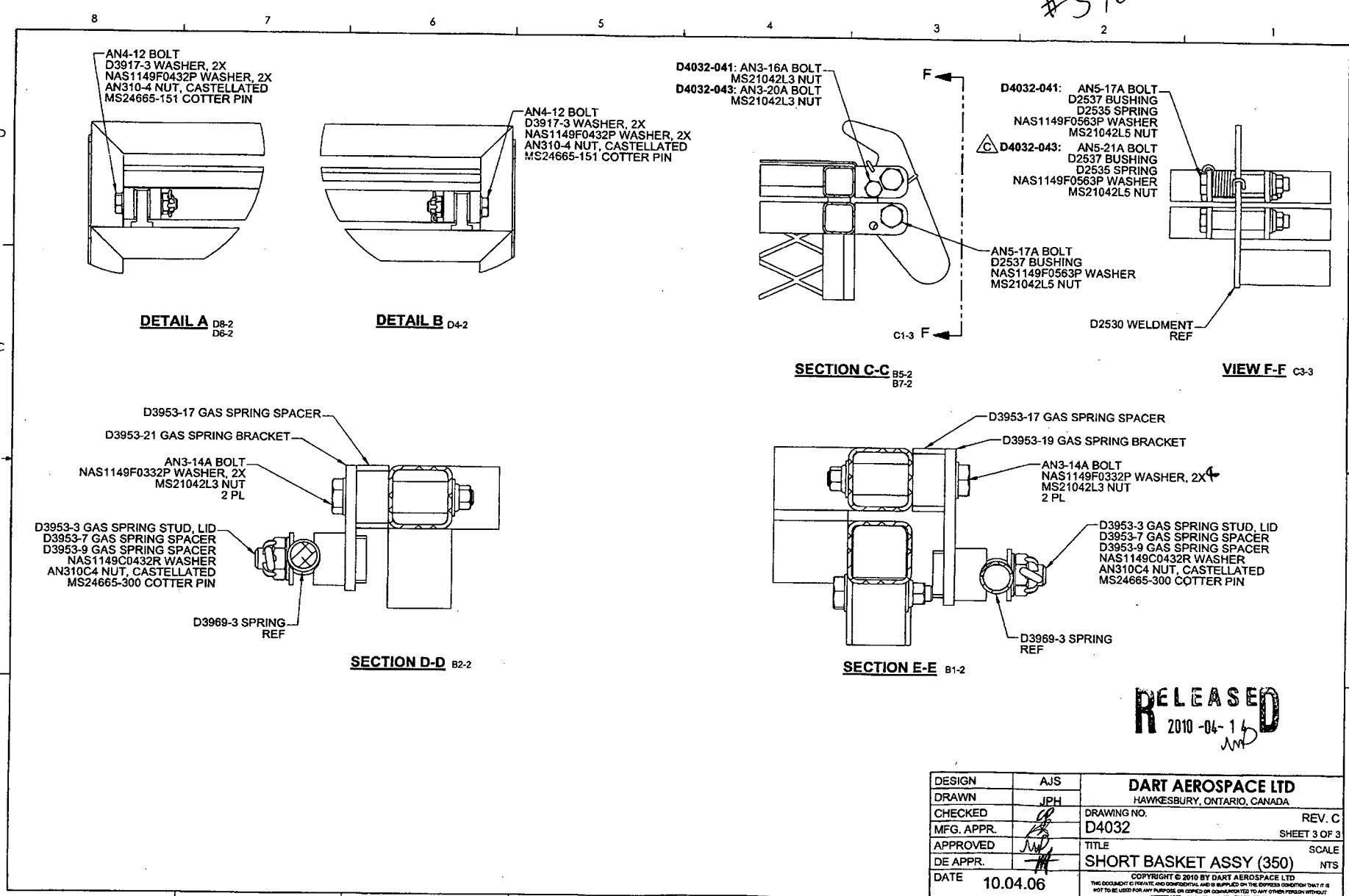


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries